

(No Model.)

R. C. ELLRICH & G. S. ALLEN.
Making Jointed Metal Rings.

No. 232,475.

Patented Sept. 21, 1880.

Fig. 1.

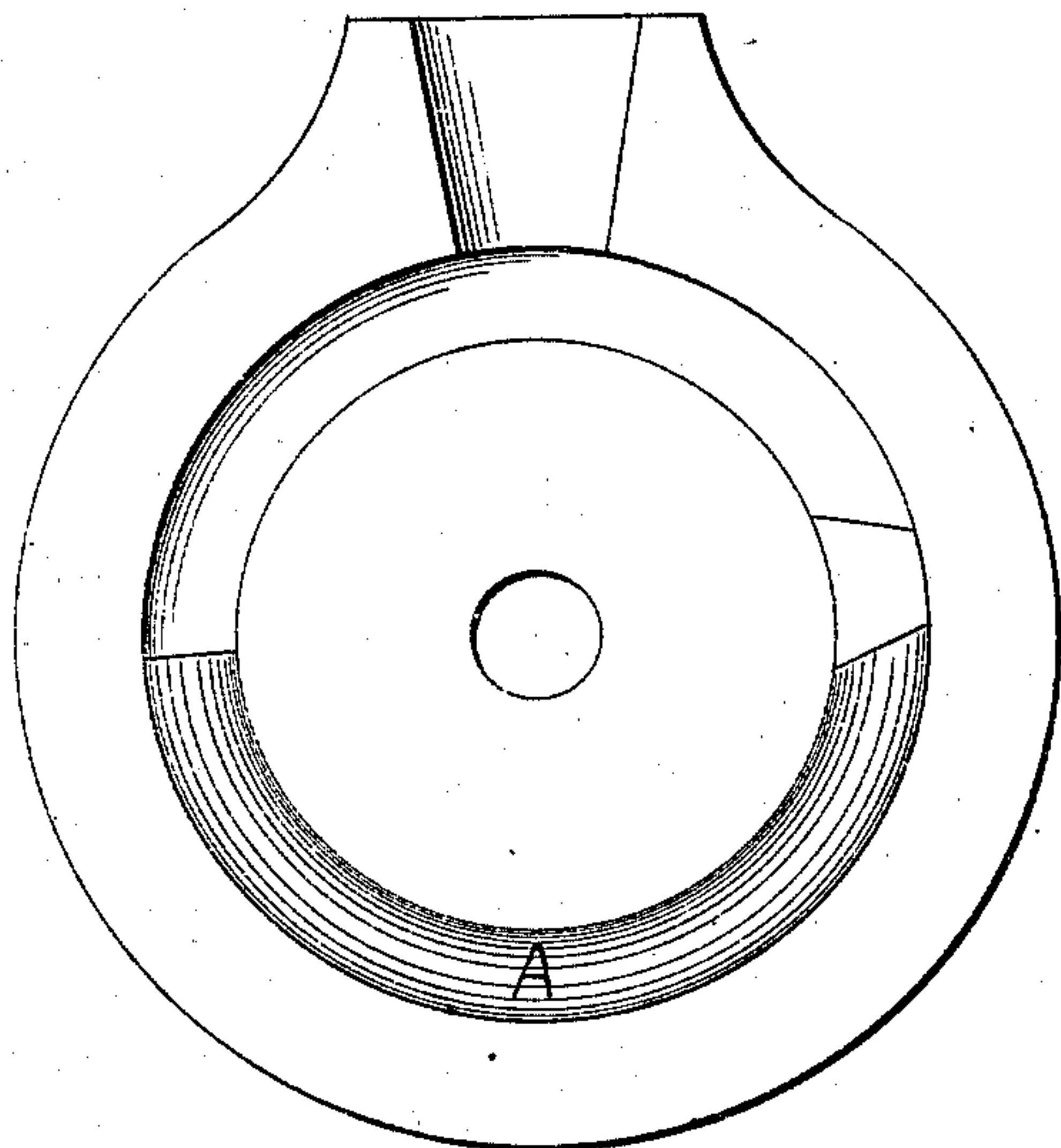


Fig. 2.

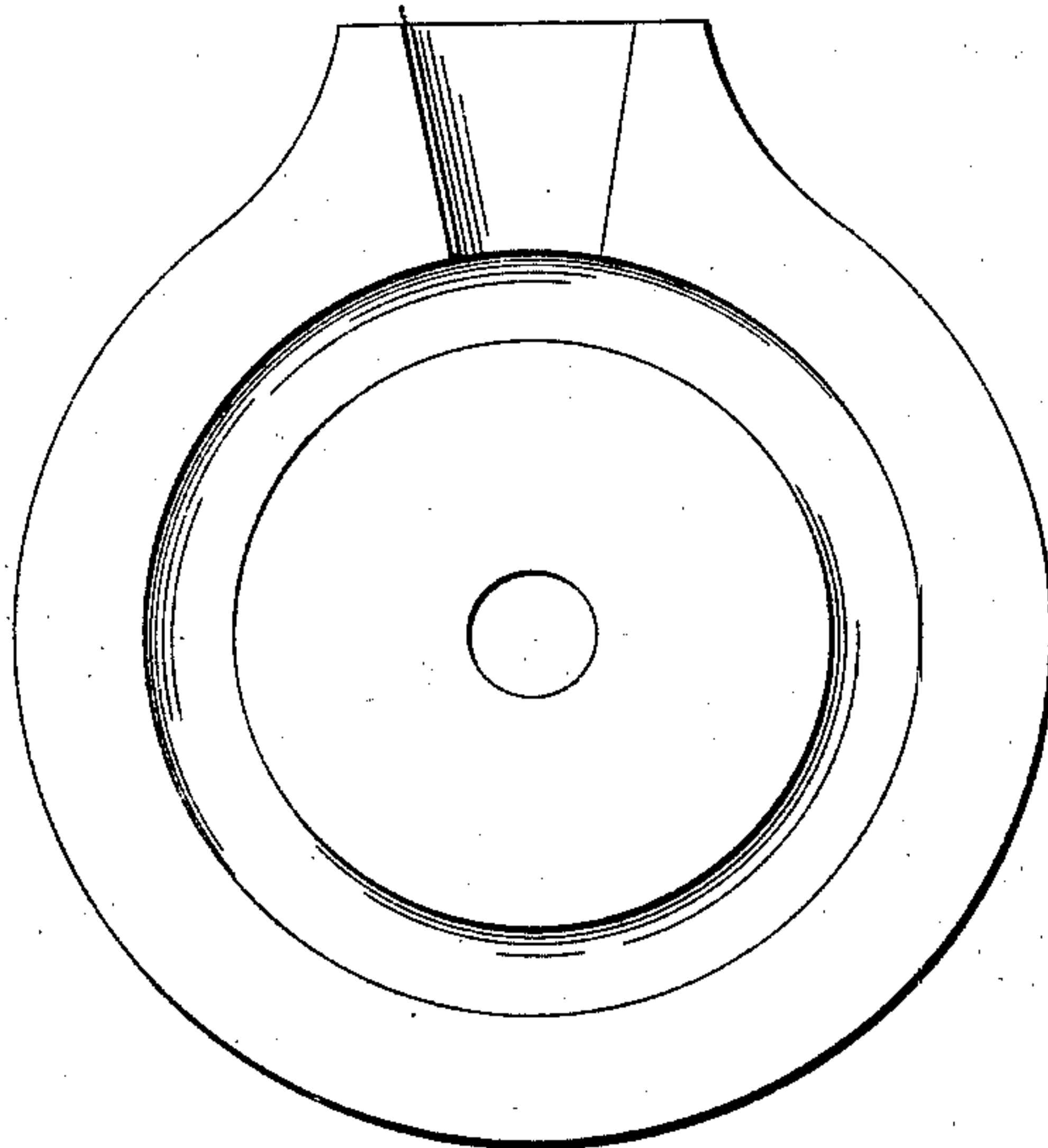


Fig. 3.

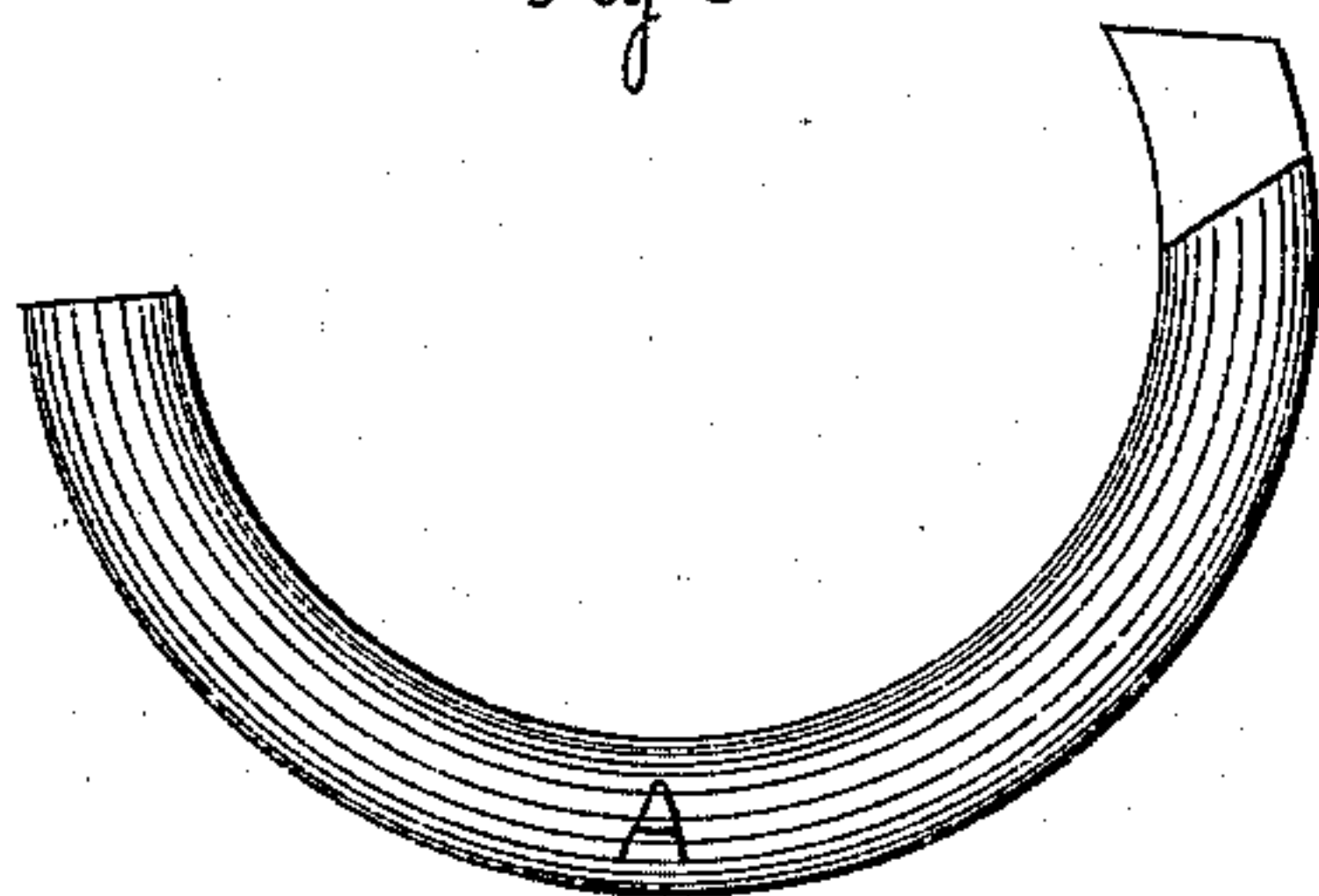


Fig. 4.

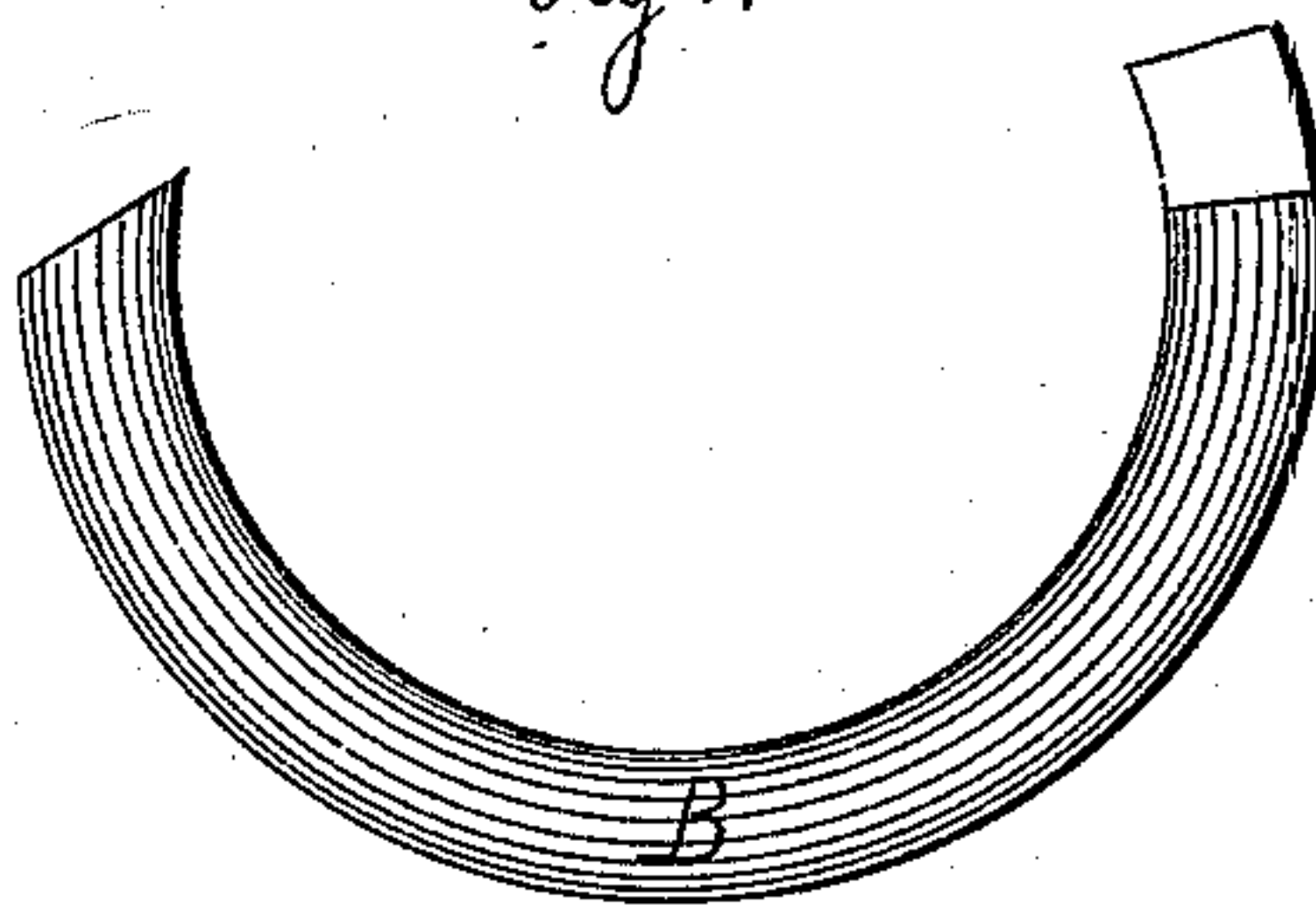


Fig. 5.

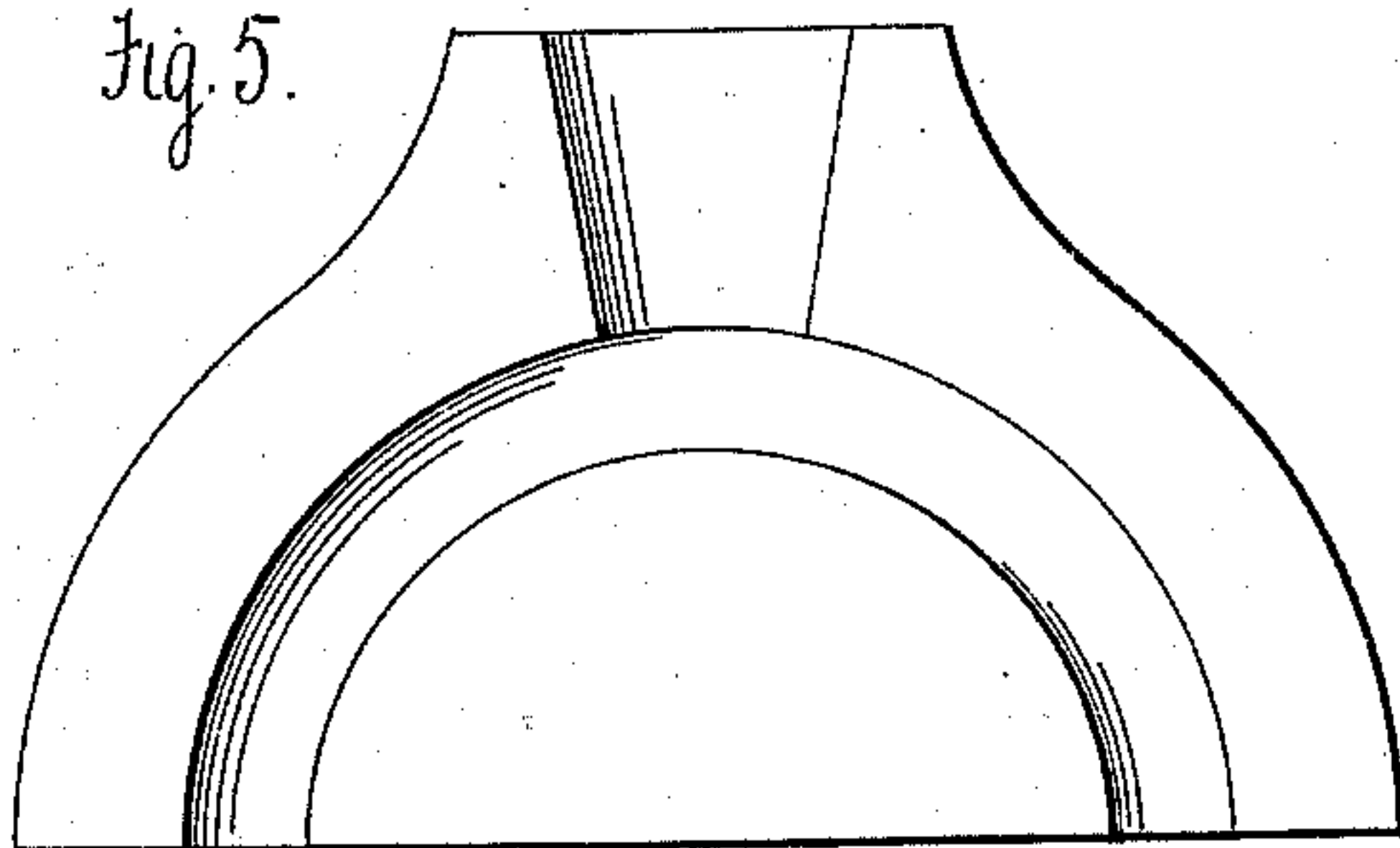


Fig. 6.

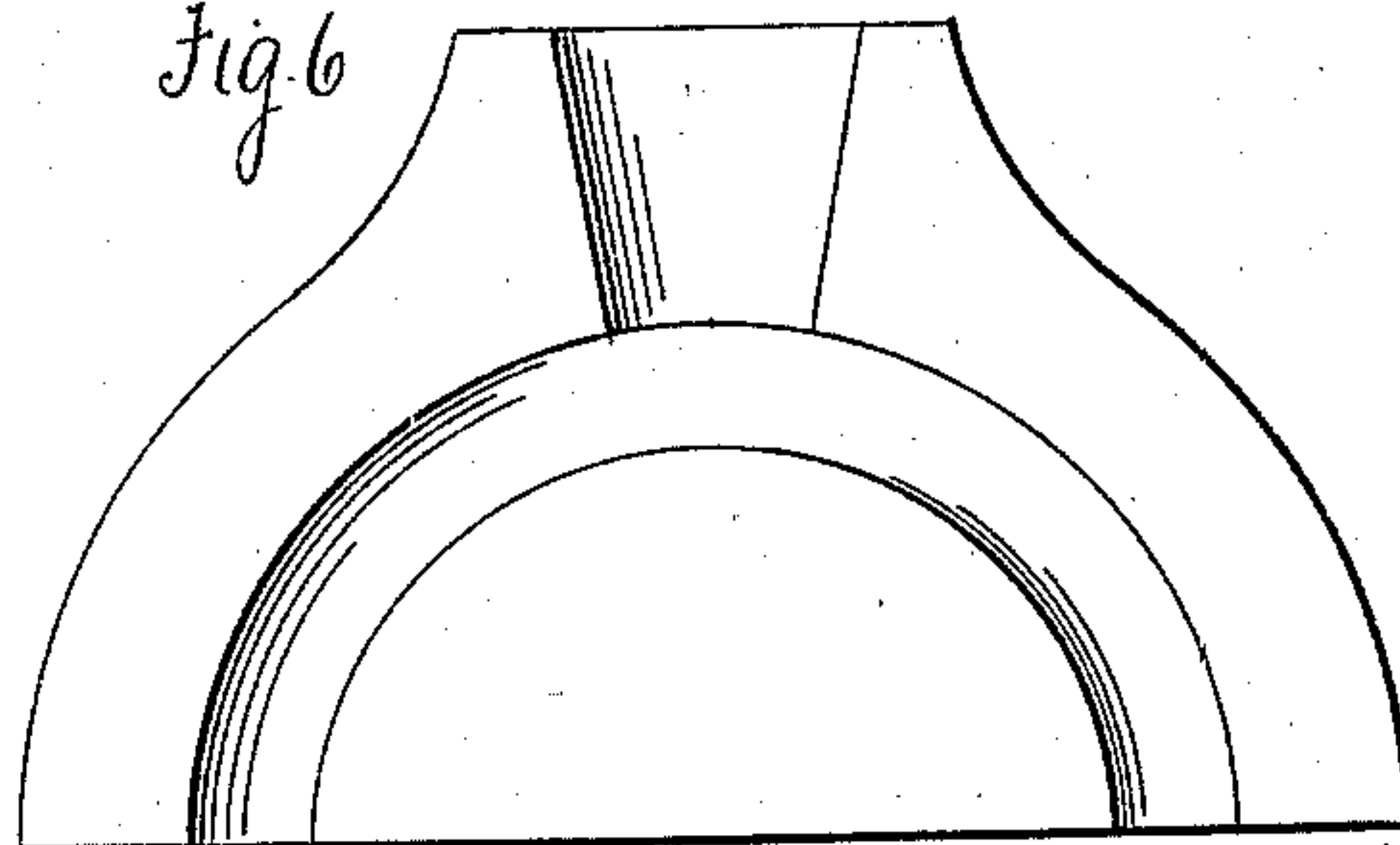
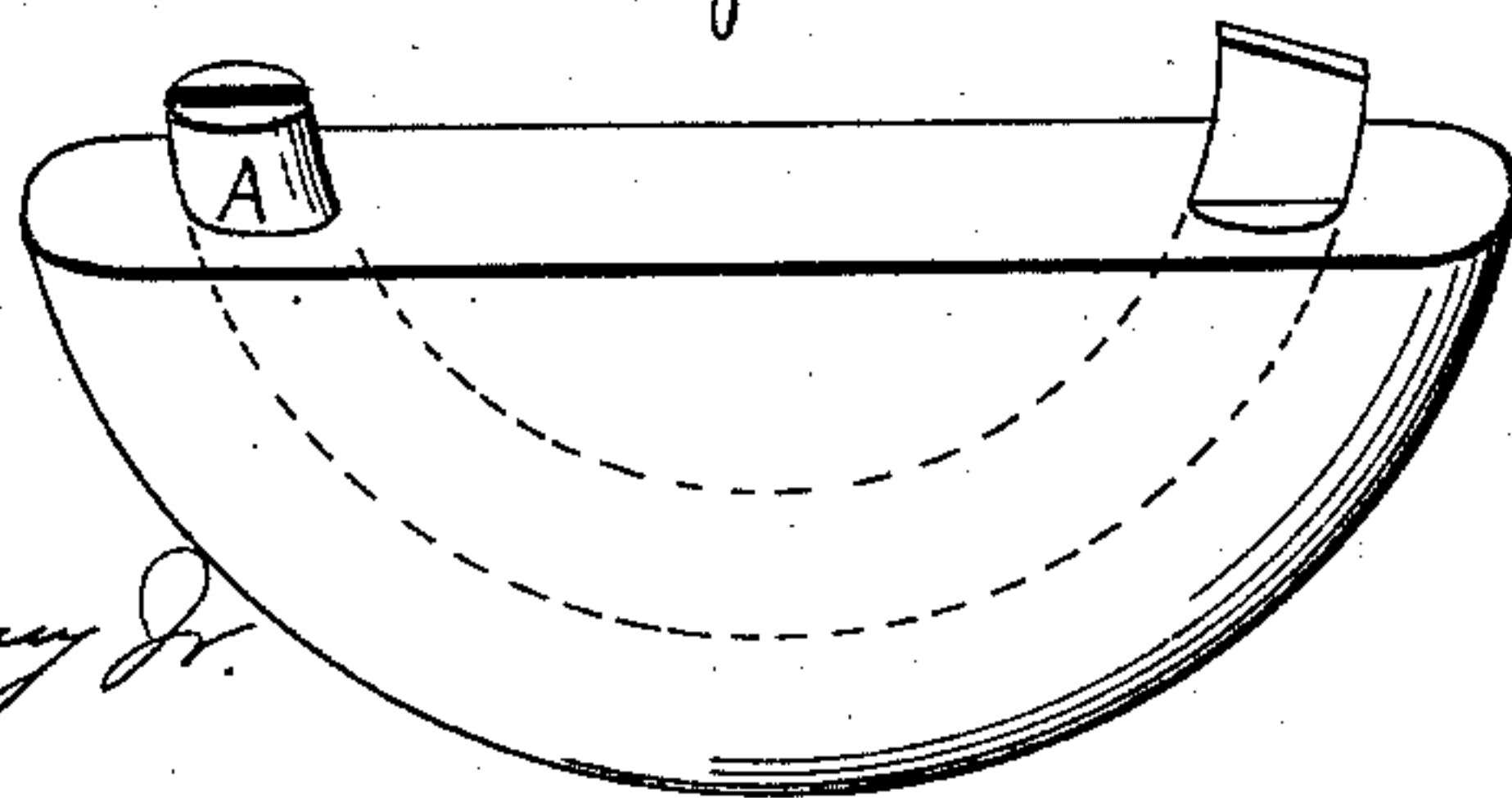


Fig. 7.



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ROBERT C. ELLRICH AND GEORGE S. ALLEN, OF SOUTHTON, CONN.

MAKING JOINTED METAL RINGS.

SPECIFICATION forming part of Letters Patent No. 232,475, dated September 21, 1880.

Application filed April 21, 1880. (No model.)

To all whom it may concern:

Be it known that we, ROBERT C. ELLRICH and GEORGE S. ALLEN, of Southington, in the county of Hartford, in the State of Connecticut, have invented certain new and useful Improvements in Making Jointed Metal Rings, of which the following is a description.

Heretofore jointed rings have been made of wire, the wire being bent into the form of semicircles, the ends of the semicircular parts being milled to form the joints, and the parts being held together by screws.

The object of our invention is to dispense with the bending, milling, and cutting a thread in one or both parts of the ring; and to this end our invention consists in casting the semicircular parts of rings in a mold containing a part of a ring made of a metal fusible at a higher temperature than the metal or alloy of which the cast rings are made, the part ring in the mold being alternated with its correspondent part ring to make an equal number of correspondent cast parts of rings, and in fastening the cast parts of rings together.

In the drawings, Figures 1 and 2 are like parts of a mold, Fig. 1 having in it a part of a ring. Figs. 3 and 4 are correspondent parts of a jointed ring. Figs. 5 and 6 are also like parts of a portion of a mold, Fig. 7 showing the remaining portion.

To make cast rings by our improved process the two parts of the mold shown in Figs. 1 and 2 are put together and inclose a part of a ring, which is made of a metal (iron or copper, for example) fusible at a higher temperature than the metal or alloy of which the cast rings are made. The melted metal is then poured into the mold in the usual manner, and the operation repeated until any required number of cast parts B correspondent to the part A in the mold are cast. The part of the ring

in the mold is then changed for its correspondent unlike part, shaped like the cast part B, and the operation of casting repeated. The cast parts are then drilled and fastened together by screws or rivets through the joints.

If desired, a screw may be put through the side of the mold and through the joints in the ring. Turning this screw out after pouring the metal and before the parts of the mold are separated leaves a threaded hole in the joint, through which a screw may pass to hold the parts of the rings together.

Figs. 5, 6, and 7 show a somewhat different mold in three parts, one part of the mold partially inclosing a part of a ring. This mold needs no description other than that the part of the mold shown in Fig. 7 must be changed for a part having a part, B, of a ring correspondent to that shown in the figure.

Having described our invention, what we claim, and desire to secure by Letters Patent, is—

The herein-described process of making jointed metal rings having two semicircular correspondent unlike cast parts, consisting, essentially, in casting any desired number of like parts in a mold containing a part of a ring fusible at a higher temperature than the metal or alloy of which the cast rings are made, in alternating the part of the ring in the mold with its correspondent unlike part, in casting, in like manner, a like number of like parts correspondent and unlike the first cast parts, and in fastening the semicircular correspondent unlike cast parts together by suitable means, substantially as set forth.

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